

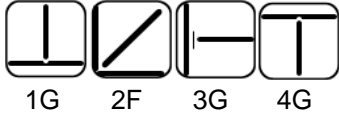
Applications

Royalfil GS-1CH is used for welding of 304H, 308H type base metal.

Characteristics on Usage

Royalfil GS-1CH is a all position 19Cr-10 Ni stainless steel gas shield flux core wire. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Carbon percentage is in the range of 0.04 – 0.08 %, which provides higher tensile and creep strength at elevated temperatures. Weld metal is of radiographic quality with easy slag removal & low spatters.

Welding Positions



Recommended Stick Out

15-20mm

Shielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow :15-20 Lit / Min

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.055	1.50	0.60	0.010	0.030	19.80	9.70	0.050	0.10
Spec. Reqd.	0.04 –0.08	0.5-2.50	1.0 Max	0.03 Max	0.04 Max	18.0-21.0	9.0-11.0	0.75 Max	0.75 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Valuesd	605	39
Spec. Reqd.	550 Min	35 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	160-210	26-30	120-210	22-26	160-210	26-30
1.60	190-250	26-30	160-250	21-27	190-250	26-30

Packing

12.5 kgs. vaccum packed plastic spool.